

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Handling/Pre									
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Offset/Setup									
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Training									
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Work Order ID 122481

Tuesday, July 22, 2014 8:37:48 AM

122481

Page 3

Item ID: D4634-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft, Center Ceiling Panel
Start Date: 8/19/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/19/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Dimensional Inspection Memo Fill out Inspection Sheet Rev A	0.00 0.00				1		Shp 14/8/26	
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				①		14-08-26	DAS 9 9-89
160 *160* Packaging Packaging Packaging	Packaging Memo	0.00 0.00						DAS 27 9-89 14/8/26	

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Doc/Data									
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Operator									
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Transport									
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Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ 1408-27

14-8.26

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Equip/Tooling									
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Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

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Picklist Print

Tuesday, July 22, 2014 8:37:48 AM

Page 1

Work Order ID: 122481

122481

Parent Item: D4634-5

D4634-5

Parent Item Name: Aft, Center Ceiling Panel

Start Date: 8/19/14

Required Date: 8/19/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev.
B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg.
Update, Material Change 13/12/18 DL IPP Rev. D 14/01/20 Dwg
Update DL IPP Rev. E Dwg Update Dim change
14/02/05 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased		No		100	sf	4,823.726	17.33	18			DAS 07 9-89
MI FXS 093-F6006-07									**				
GE PLASTICS LEXAN SHEET (Grey)													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT023	4823.72662	
114459	229.26	
123105	38	
124501	543.5	
m128668	181.35	
m129014	102.33332	
m129471	1025.3333	
m129738	2703.95	

14/07/30

18 sq ft.

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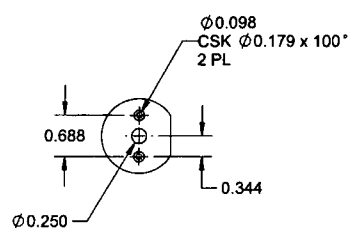
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Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

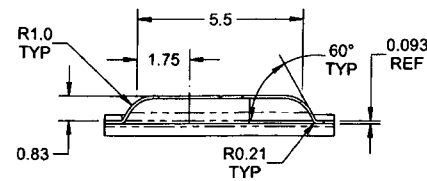
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

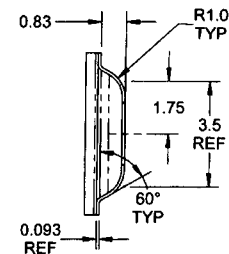
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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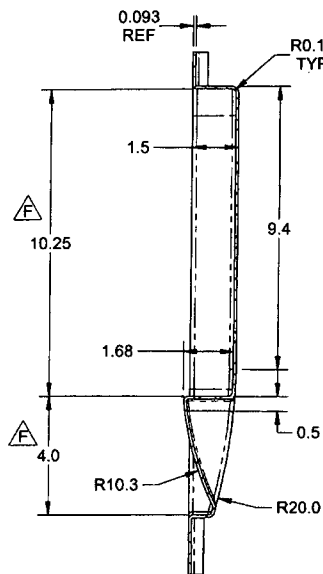
DETAIL C
SCALE 4X
B7-10
B4-12
B4-14



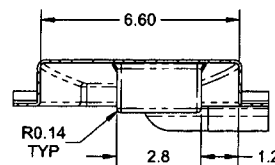
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SCALE 2X
B6-11
C4-13
C4-15



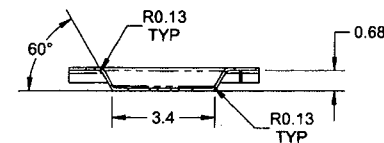
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SCALE 4X
B5-11
C4-13
C5-15



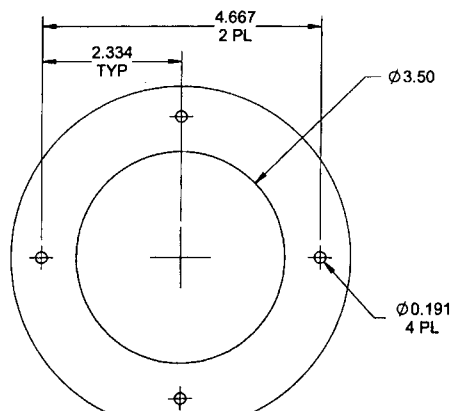
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SCALE 4X
C5-11



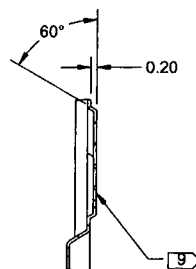
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C5-11



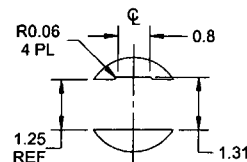
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SCALE 2X
B6-13



DETAIL B
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2 PL
B7-10



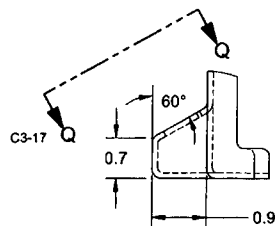
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SCALE 4X
TYP
B2-13
C2-13
B2-14
C2-14



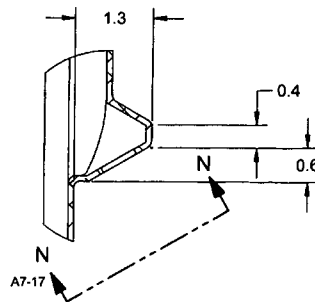
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SIMILAR
C4-10
B4-12
C4-14

RELEASED
2014 FEB 25

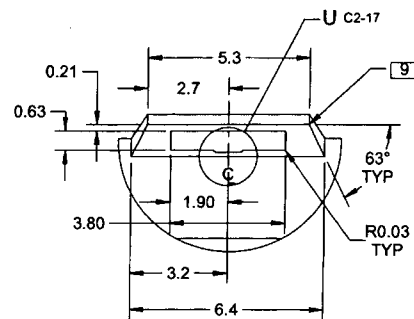
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. F
MFG. APPR.	DC	D4634	SHEET 16 OF 17
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CENTER CEILING PANELS	NTS
DATE	14.02.03	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



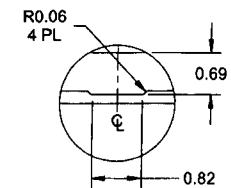
DETAIL P B3-14
SCALE 2X



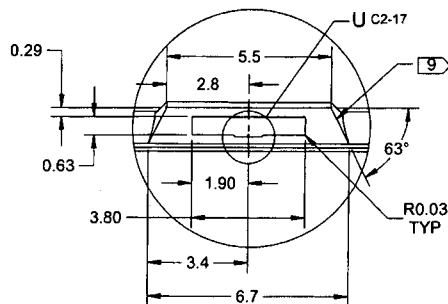
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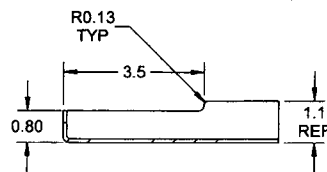
DETAIL Q B4-15
SCALE 0.5X D8-17



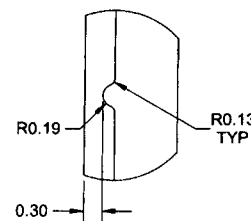
DETAIL U B7-17
SCALE 0.5X D3-17



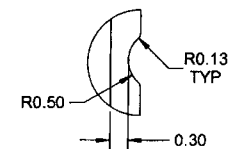
DETAIL N C5-17
SCALE 0.5X B4-15



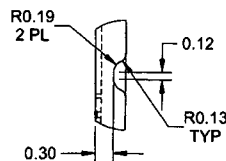
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10
SCALE 4X C3-10
B2-12



DETAIL S B3-10
SCALE 4X C2-12



DETAIL T C2-14
SCALE 4X

RELEASED
2014 FEB 25

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. F
MFG. APPR.	BC	D4634	SHEET 17 OF 17
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CENTER CEILING PANELS	NTS
DATE	14.02.03	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order:	B122481
Description: Aft Center Ceiling Panel		Part Number:	D4634-5
Inspection Dwg: D4634	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.20	+/-0.030	10.20	✓		S Feb-21	
11.25	+/-0.030	11.25	✓		"	
15.91	+/-0.030	15.91	✓		"	
1.25	+/-0.030	1.249	✓		"	
4.55	+/-0.030	4.57	✓		"	
21.50	+/-0.010	21.50	✓		"	
13.88	+/-0.030	13.88	✓		"	
1.25	+/-0.030	1.247	✓		S Feb-08	
21.53	+/-0.030	21.53	✓		S Feb-21	
12.00	+/-0.030	12.00	✓		"	
24.00	+/-0.030	24.00	✓		"	
20.50	+/-0.030	20.50	✓		"	
Ø0.250	+0.005/-0.001	0.2514	✓		S Feb-08	
39.75	+/-0.030	39.75	✓		S Feb-21	
1.300	+/-0.010	1.299	✓		S Feb-08	
Ø0.129	+0.005/-0.001	0.1285	✓		"	
Ø0.250	+0.005/-0.001	0.251	✓		"	
11.66	+/-0.030	11.66	✓		"	
31.41	+/-0.030	31.41	✓		"	
Ø2.030	+0.012/-0.001	2.041	✓		"	
3.80	+/-0.030	3.80	✓		"	
0.63	+/-0.030	0.646	✓		"	
0.50	+/-0.030	0.519	✓		"	
1.05	+/-0.030	1.067	✓		"	

Measured by:	DAS 27 9-89	Audited by:	DAS 9 9-89	Preliminary Approval:	
Date:	14/8/26	Date:	14-8-26	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	